

Work Order ID 79179

January-23-12 10:46:09 AM

79179

Page 1

Item ID: D2804-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket
 Start Date: 23/01/2012 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 06/02/2012 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/01/23 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2804	Rev C								

100 0.00

100

Waterjet

FLOW CNC Waterjet

606' 5000' 10

FLOW WATER JET

Memo

1-Cut as per File D2804-1-2_Blank

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

0.00

R12-1-30

(10)

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per folio FA103

0.00

0.00

02/25 12-02-01 (x10)

120

120

QC

Quality Control

QC2- Inspect parts off machine FA1/FAIB

Memo

0.00

0.00

02/25 12-02-01 (x10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2804-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 23/01/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 06/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
145	QC3- Inspect Part Finish	0.00							
145									
QC	Memo	0.00							
Quality Control									

10X6 M-12/02/02

10 16 12-2

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 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>ST.</i>	0.00							<i>10</i>
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/02/02 *10*

12/2/2 *MF*

12-02-02

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Picklist Print

January-23-12 10:46:13 AM

Page 1

Work Order ID: 79179

79179

Parent Item: D2804-1

D2804-1

Parent Item Name: Bracket

Start Date: 23/01/2012

Required Date: 06/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP A00.11.06New IssueEC

IPP B06.05.30 Blanks on wtjetEC

IPP Rev:C As per Rev C 06-11-09 JLM

IPP Rev:D Removed Tumbling 08-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6B0.500X10.00

Purchased

No

f

24.1000

7.5

10

M6061T6B0 500X10 000

**

B 12-1-30

6061-T6 Bar .500 x 10.00

Location

Loc Qty

Loc Code

MAT004

24.1

119513

24.1

M120421

10

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DART AEROSPACE LTD		Work Order: 79179
Description: Bracket		Part Number: D2804-1
Inspection Dwg: D2804	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	0.757	✓		vern	
Ø0.191	+0.005/-0.001	.1915	✓		vern	
1.420	+/-0.001	1.421	✓		"	
Ø0.507	+0.000/-0.001	.5064	✓		snap gauge micrometer	
0.250 deep	+/-0.010	.248	✓		depth gauge	
Ø0.507	+0.000/-0.001	.5064	✓		snap gauge micrometer	
Ø0.191	+0.005/-0.000	.192	✓		caliper	
6.933	+/-0.010	6.934	✓		"	
7.578	+/-0.010	7.579	✓		"	
12.304	+/-0.010	12.309	✓		"	
0.125	+/-0.010	.123	✓		"	
0.500	+/-0.010	.5015	✓		"	
0.125	+/-0.010	.131	✓		"	
0.250	+/-0.010	.249	✓		"	
0.875	+0.000/-0.001	.875	✓		snap gauge micrometer	
0.250	+0.000/-0.005	.248	✓		depth gauge	

Measured by: <i>ET/mf</i>	Audited by: <i>RP</i>	Prototype Approval:	N/A
Date: 12-02-01	Date: 2.2.2	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM	
B	06.06.05	Removed dimensions 12.625, 0.608, 0.437, 2.654	KJ/EC	
C	06.11.10	Revised per drawing revision C	KJ/JLM	
D	09.03.10	Tolerance revised for Ø0.757	KJ/DD	<i>[Signature]</i>

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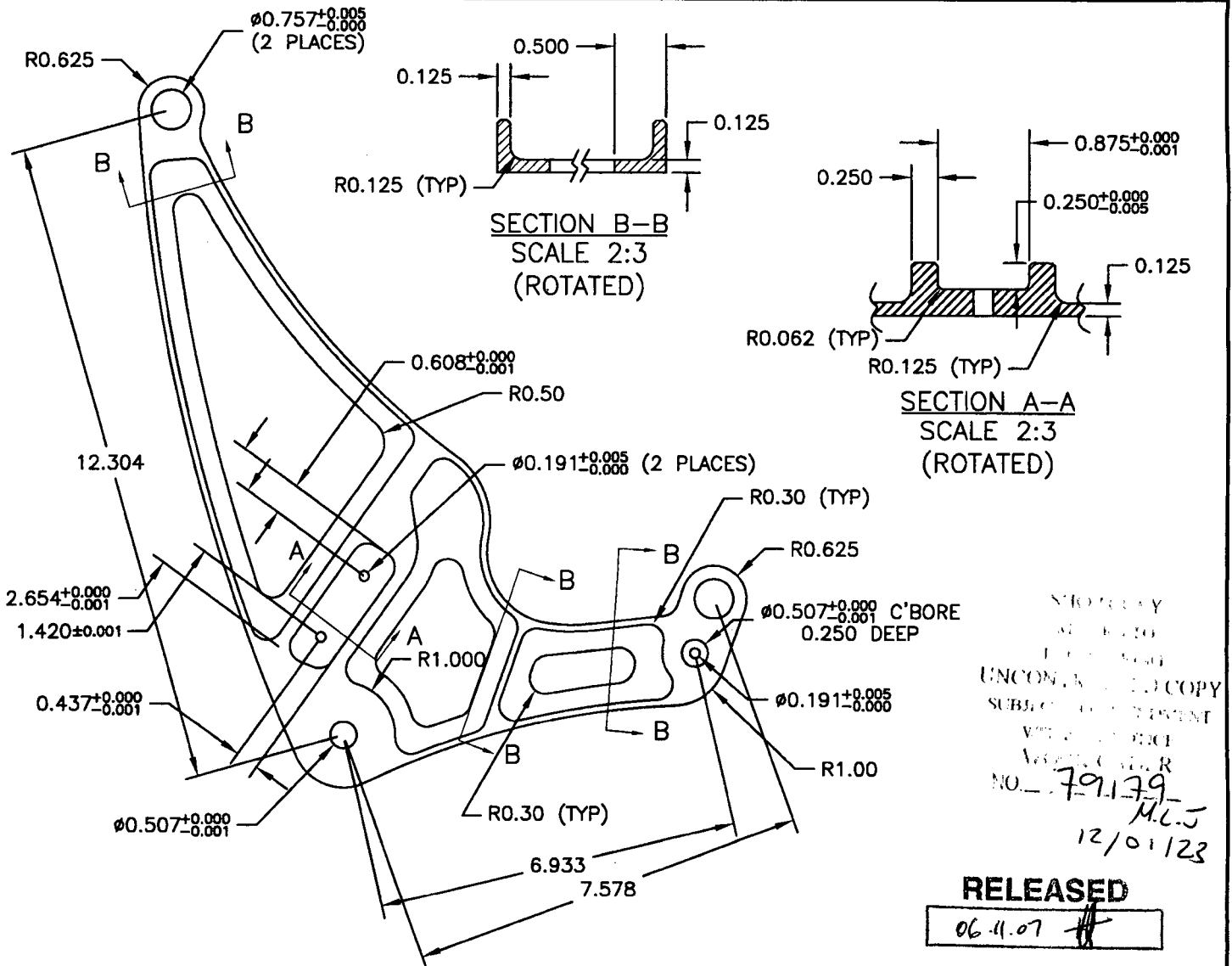
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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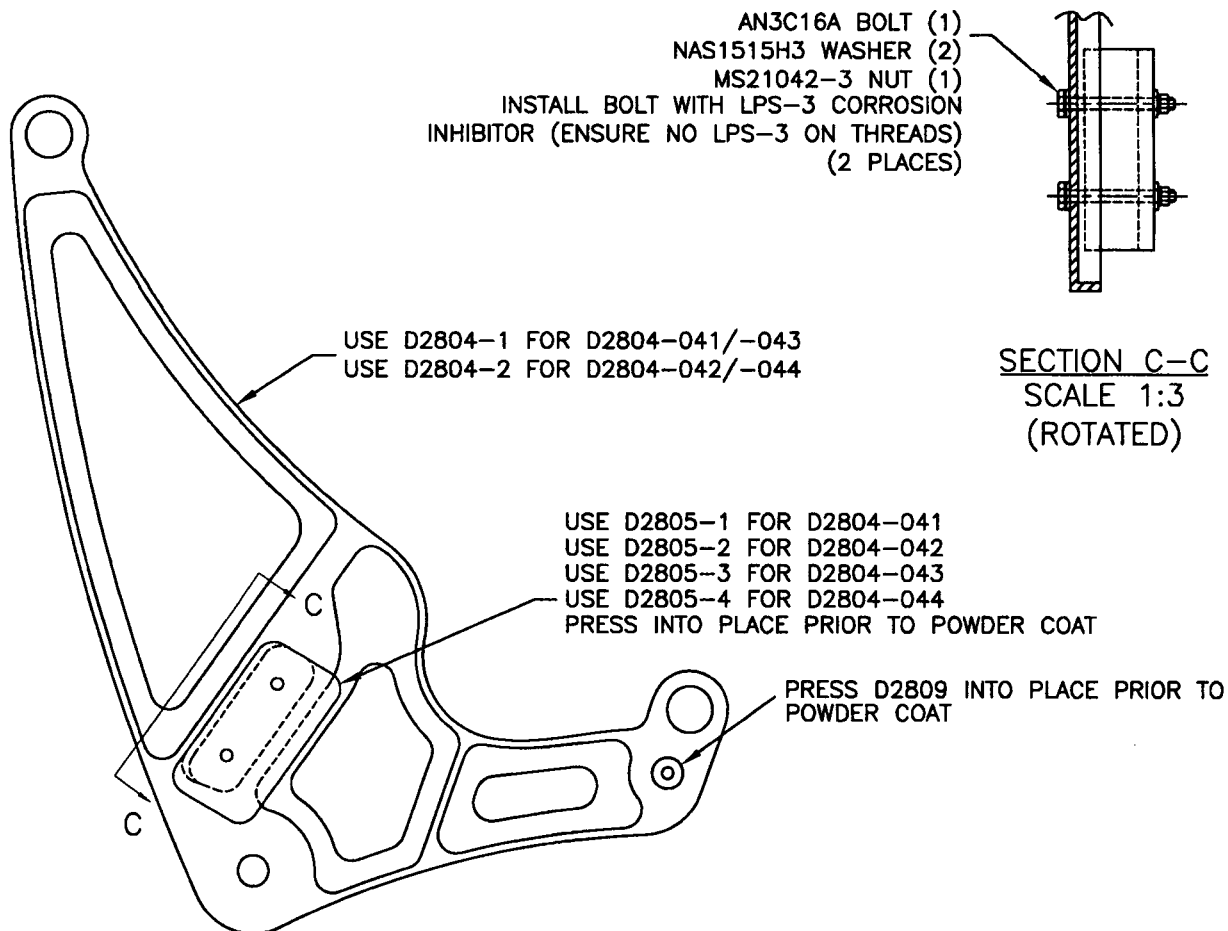
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79179

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



SECTION C-C
SCALE 1:3
(ROTATED)

RELEASED

06.11.07 *[Signature]*

D2804-041/-043 BRACKET ASS'Y (SHOWN)

D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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